

Work Order ID 71698

Thursday, July 07, 2011 12:56:12 PM



Page 1

Item ID: D4001-1

Accept



Setup Start



Revision ID:

Item Name: Fitting

Stop



Start Date: 7/7/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 7/21/2011 Req'd Qty: 4.00

Customer:

Reference:

Approvals:

Process Plan: CL

Date: 4/07/07

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4001

A

100



Bandsaw

Jeaspa Bandsaw

Memo

cut blank 4.200" long

0.00

0.00

ant/K.K. 11/08/10

4

φ

110



HAAS 1

HAAS CNC vertical machine #1

Memo

MILL AS PER DWG AND FOLIO FA912

FOLIO REV: AA

DWG REV: A

DEBURR

0.00

0.00

JK 11-08-18

(4)

φ

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 71698

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Revision ID:

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Item Name: Fitting

Start Date: 7/7/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 7/21/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00		2K 11-08-18		4	0		
130 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		BA 11/08/18		4	0		
140 Packaging Packaging	Identify as per dwg & Stock Location: <u>WA</u> Memo	0.00 0.00		KA 11-08-20		4	0		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 71698

Thursday, July 07, 2011 12:56:12 PM



Page 3

Item ID: D4001-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Fitting

Start Date: 7/7/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 7/21/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/8/22

11/8-08-22

(4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, July 07, 2011 12:56:09 PM

Page 1

Work Order ID: 71698



Parent Item: D4001-1



Parent Item Name: Fitting

Start Date: 7/7/2011

Required Date: 7/21/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPPP REV:A NEW ISSUE 10-02-22 JLM VERIFIED BY:EC IPP rev B
10.05.13 ecn10-562 EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.000X04.00 0		Purchased		No		100	f	26.3100	0.3501	1.474105			



6061-T6 Bar 1.00 x 4.00



FK 11/08/10
OK

Location

Loc Qty

Loc Code

MAT004

26.31

• 107221

22.23

• 114352

2.58

• 116808

1.5

0.75

0.713

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	71698
Description: Fitting		Part Number:	D4001-1
Inspection Dwg: D4001 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.71	+/-0.030	.697	✓		Nern 23	
0.12	+/-0.030	.125	✓		"	
Ø1.89	+/-0.030	1.890	✓		"	
0.20	+/-0.030	.190	✓		"	
R0.51	+/-0.030	.51	✓			
Ø3.94	+/-0.030	3.936	✓		"	
1.28	+/-0.030	1.280	✓		"	
Ø2.91	+/-0.030	2.910	✓		"	
1.24	+/-0.030	1.24	✓		"	
10-32 UNF	N/A		✓			
1.18	+/-0.030	1.18	✓			
Ø1.65	+/-0.030	1.653	✓			
1.36	+/-0.030	1.36	✓			
1.19	+/-0.030	1.19	✓			

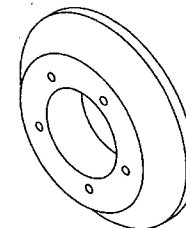
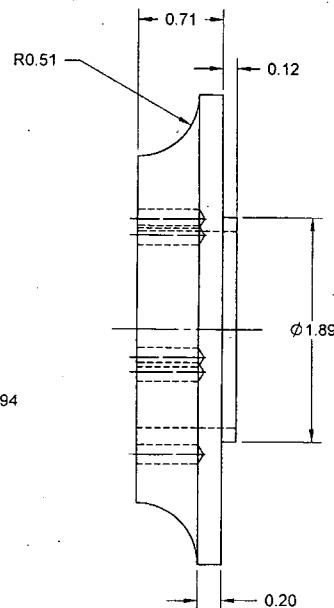
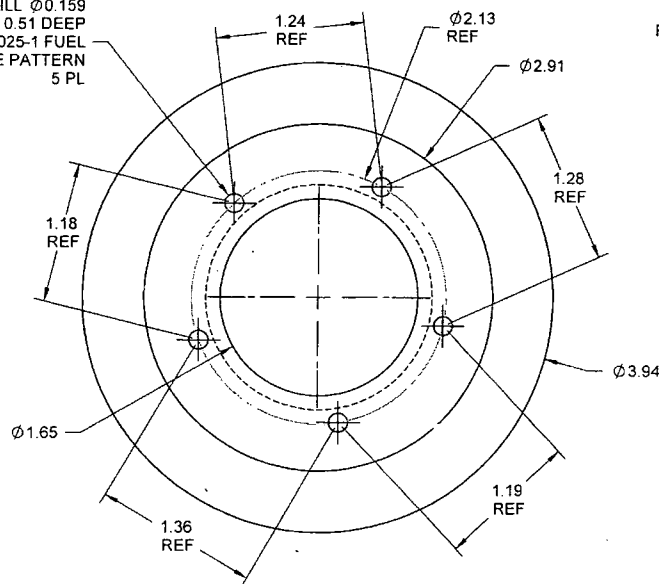
Measured by: <u>SK</u>	Audited by: <u>B.A</u>	Preliminary Approval:
Date: <u>11-08-18</u>	Date: <u>11/08/18</u>	Date:

Rev	Date	Change	Revised by	Approved
A	11.03.08	New Issue	KJ	

DART AEROSPACE
PART NUMBER
D4001-1

JOHN CAMERON AVIATION
PART NUMBER
JCA-M47-1-08

DRILL $\phi 0.159$
TAP 10-32 UNF X 0.51 DEEP
SPACED TO MATCH D4025-1 FUEL
SENDER UNIT HOLE PATTERN
5 PL



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 71699
CR1107105

D4001-1 FITTING

NOTES:

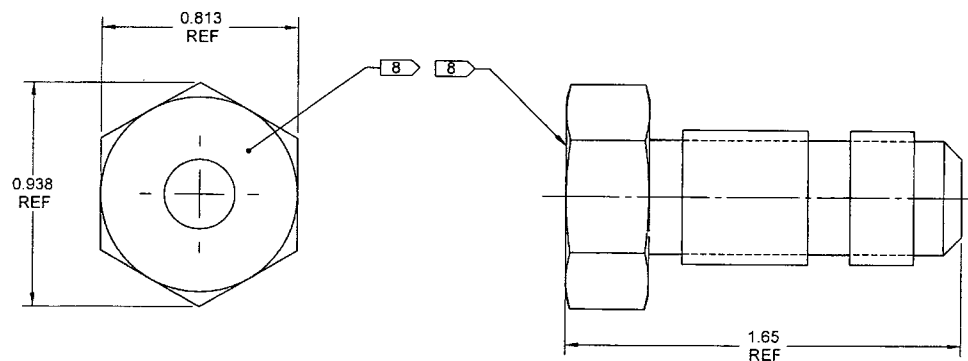
- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ALUMINUM BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
PER AMS-QQ-A-200/8 (OR AMS 4160)
REF DART SPEC M6061T6R
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.47 lbs

RELEASED
2010-05-05
MA

A		NEW ISSUE		10.02.05	
REV.	DESCRIPTION	BY	DATE		
DESIGN				DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN					
CHECKED				DRAWING NO.	REV. A
MFG. APPR.				D4001	SHEET 1 OF 2
APPROVED				TITLE	SCALE
DE APPR.				FITTING	NTS
DATE	10.02.05	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4001-3	JCA-M47-2-28 (AN832-6D-JCA)

AN832-6D
BEFORE MODIFICATION
REF



D4001-3 FITTING

NOTES:

- 1) MATERIAL: MADE FROM AN832-6D
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4001-3" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.04 lbs
- 8) BRUSH ALODINE MACHINED SURFACE

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. D4001 REV. A
MFG. APPR.		SHEET 2 OF 2
APPROVED		TITLE FITTING SCALE NTS
DE APPR.		
DATE	10.02.05	

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